

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009549**Date Inspected:** 07-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Chuan Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly-

Caltrans QA Inspector observed the following work in progress:

ABF QC Magnetic Particle Testing (MT) technicians testing bottom and side panel stiffener hold back welds at panel point 29 on OBG segment 5AE.

ABF QC removing paint on side and bottom panel hold back welds at panel point 29 on OBG segment 5AW.
Bay 10-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of North Tower Skin Plate longitudinal stiffener welds NSD1-SPSA3-4-2A. ZPMC welder was identified as 040533. ZPMC QC is identified as Wang Chuan Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-TC-U5-F.

Flux Cored Arc Welding (FCAW) of North Tower Lift 3 diaphragm to diagonal stiffener welds, NSTL3-3 C/K- 4 and 5 located on the 89 meter top diaphragm. ZPMC welders were identified as 057266 and 057244. ZPMC QC is identified as Tu Jun. The welding appeared to be in conformance with welding procedure specification,

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WPS-B-T-4333-TC-P5-F.

Flux Cored Arc Welding (FCAW) of North Tower Lift 3 diaphragm to diagonal stiffener weld, NSTL3-3 I/K-114 located on the 109.5 meter top diaphragm. ZPMC welders was identified as 050041. ZPMC QC is identified as Tu Jun. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4333-TC-P5-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation occurred between QC and QA this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
